SAR Semi-Automatic Rifle

SAR 1 Cal. 7.62x39mm
SAR 2 Cal. 5.45x39mm
SAR 3 Cal. 5.56 NATO (.223)

OPERATIONAL MANUAL



Manufactured In Romania

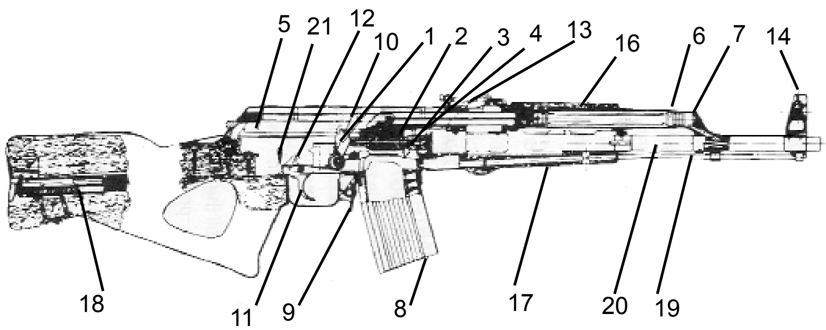
This manual is for informational purposes only. All repairs and, or, adjustments should be made by a qualified gunsmith.
The owner of this firearm is responsible for it's safe use and storage.

Introduction

The SAR semi-automatic rifle is well made, reliable, and has several interesting features such as a hard chrome lined barrel, hard chrome plated piston, and can be completely taken down without tools.

The use of reloaded, re-manufactured, hand loaded, or other nonstandard ammunition may result in damage to the user or rifle.

The manufacturer and importer cannot accept responsibility for malfunctions resulting from the use of nonstandard defective ammunition.



Parts Identification

1. Hammer
2. Bolt
3. Firing Pin
4. Bolt Carrier
5. Return Spring
6. Piston
7. Gas Cylinder
8. Magazine
9. Magazine Catch
10. Hammer & Trigger Spring
11. Trigger
12. Disconnector
13. Rear Sight Leaf
14. Front Sight
16. Hand Guard
17. Fore End
18. Accessories Case
19. Cleaning Rod
20. Barrel
21. Safety Lever

DISASSEMBLY AND ASSEMBLY

I. General Instructions:
The following instructions should be observed during disassembly and assembly:
1. Before the rifle is disassembled, make sure there is no round in the chamber or magazine.
2. The rifle should be disassembled on a table or bench.
3. The parts should be laid out in order of disassembly.
4. Force should not be used to remove or disassemble parts, as it may result in damage to the parts.
5. Only accessories in good condition should be used.
6. When tightening or loosening screws, hold the screwdriver firmly to prevent damage to the screw heads.

Field Stripping

NOTE: Ensure the rifle and magazine are not loaded.

1. Remove the magazine from the rifle by holding the rifle forend with the left hand, rotate the rifle a certain amount, pushing the magazine away, grasp the magazine with the right hand, and depress the magazine catch with the thumb of the right hand, rotate the magazine forward and remove it from the receiver hole (Fig 1).

2. Take the rifle off safety. Rotate the safety lever downward as far as possible with the thumb of the right hand.

3. Check to see that there is no round in the chamber. Pull the bolt carrier to the rear and inspect the chamber and bolt face.

Figure #1



4. Remove the cleaning rod from the rifle. Place the stock of the rifle on the ground and hold this position by using the right hand and, bending it slightly, remove the cleaning rod head from the stop in the base of the front sight, move the cleaning rod upward so that its head leaves the forward face of the front sight, remove the cleaning rod with the right hand (Fig 2). You may use a punch to remove the cleaning rod.

Figure #2



5. Remove the receiver cover. Lean the rifle against a table and hold the forward part of the butt with the right hand, depress the guide face with the thumb into the cover hold and raise the cover with the left hand (Fig 3).



Figure #3

6. Remove the return mechanism from the rifle. Holding the rifle by the forward portion of the receiver with the left hand, move the return spring guide forward until its rear face leaves the groove in the receiver rear plate, lift the guide rear face and remove the return mechanism from the bolt carrier channel (Fig 4).



Figure #4

7. Remove the bolt carrier with bolt from receiver. Holding the rifle by the forward portion of the receiver with the left hand, and the cocking handle with the right hand, bring the bolt carrier with bolt to the rear as far as possible, and moving the bolt carrier forward a distance of 1 to 2 mm. Lift the rear portion of the bolt carrier and remove it together with the bolt from the receiver.

8. Remove the bolt from the bolt carrier. Take the bolt carrier in the left hand with the cam surface facing upward, and rotate the bolt a small amount with the right hand so that the guide lug leaves the wide part of the variable groove in the bolt carrier and then move the rear as far as possible, rotating the bolt, remove its lug from the variable groove of the bolt carrier and remove the bolt carrier. Remove the bolt from the bolt carrier by moving it forward (Fig. 5).

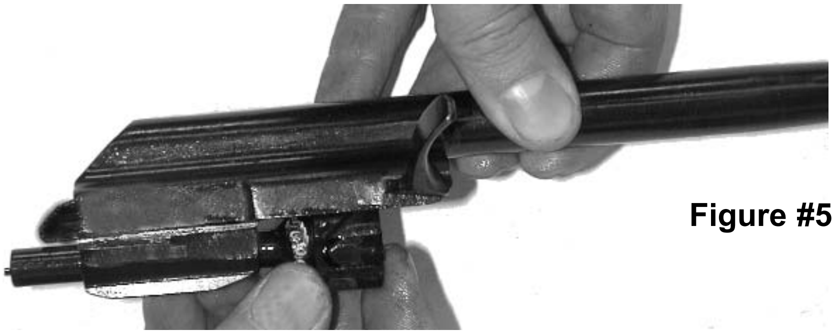


Figure #5

9. Remove the gas tube with the hand guard from the barrel. Holding the rifle by the forward portion of the receiver with the left hand, rotate the lock lever upward with the right hand, rotate the gas tube upward by means of the rear end of the receiver and remove it from the gas cylinder.

Assembly After Stripping:

1. Attach the gas tube with the hand guard to the barrel. Holding the rifle by the forward portion of the receiver with the left hand, install the gas tube on the gas cylinder with the right hand and depress the rear end of the gas tube as much as possible, rotate the gas tube lock downward so that the lever lock enters the recess in the right wall of the rear sight base.

2. Attach the bolt to the bolt carrier. Grasp the bolt carrier with the left hand with the cam surfaced upward, and with the right hand install the bolt in the bolt carrier lug, rotate the bolt so the guide edge enters the variable groove in the bolt carrier, and then move the bolt forward.

3. Install the bolt carrier with bolt in the receiver. hold the rifle by the forward portion of the receiver with the left hand, and with the thumb of the right hand, hold the bolt in the forward position, then insert the piston into the gas tube and insert the bolt carrier with the bolt into the receiver so that the guide lug of the bolt carrier and the lugs of the bolt are opposite the notches in the guide on the receiver, depress the rear portion of the bolt carrier so that its guide grooves coincide with the guides of the receiver, and move the bolt carrier to the extreme forward position (Fig 6).



Figure #6

4. Install the return mechanism in the bolt carrier. Hold the rifle by the forward portion of the receiver with the left hand, and with the right hand insert the return mechanism into the bolt carrier channel, move the return mechanism rear face forward and placing its guide lugs opposite the grooves in the receiver rear plate, depress the return mechanism rear face, in this position, the rear faces should enter the groove in the receiver rear plate.

5. Install the cover on the receiver. Hold the rifle by the forward portion of the receiver with the left hand, and with the right hand insert the cover so that its forward face enters to semicircular groove in the rear sight base and move the cover forward as far as possible, press the rear portion of the cover forward and downward, thus completing the installation.

6. Install the cleaning rod in the rifle.

7. Install the magazine in the rifle. Hold the rifle by the fore end with the left hand, and rotate the rifle a certain amount, insert the upward forward portion of the magazine into the opening in the receiver with the right hand so that the magazine front stop enters the notch in the receiver, rotate the magazine to the rear so that the magazine catch is engaged by the magazine rear stop (Fig 7)

8. Release the hammer from the semiautomatic sear, and turn on the safety, rotating the selector lever upward.



Figure #7

1. General procedure for preventing and elimination of stoppages: With proper maintenance storage and handling; the rifle is reliable in use. However, as a result of careless handling, dirty parts, low-grade rounds, and also as a result of wear of the parts caused by extensive use, normal operation of the rifle can be affected, causing stoppages during fire. The majority of stoppages can be easily eliminated simply by cocking the rifle that is by bringing to the rear the bolt carrier and releasing it.

To Prevent Stoppages:

1. Prepare the rifle for firing properly.

2. Inspect, clean, and lubricate the rifle.

3. Carefully observe the cleanliness and operation of bolt carrier, bolt, gas channels, and magazines.

4. Perform timely maintenance.

5. Carefully inspect ammunition before firing.

6. Fire only new serviceable and clean ammunition.

7. Disassemble and clean the rifle whenever it is dirty. If the rifle is used in extremely cold weather a considerable period of time, before loading it is necessary to move the bolt carrier forward and rearward several times manually. If a stoppage occurs whereas a chambered round fails to fire, continue to point the rifle in a safe direction and wait approximately 30 seconds. This is to avoid possible delay detonation of a “hangfire” type malfunctioning cartridge. Recock the rifle immediately manually and continue firing, if recocking the rifle does not eliminate the stoppage, it is necessary to ascertain the cause and correct it.

SAFETY FIRST

Firearms can be dangerous and can cause serious injury or death. Proper and safe firearms handling is the responsibility of anyone who touches or uses a firearm. Safety has to be the primary consideration of anyone using a firearm.

When purchasing a firearm, you assume responsibility for its safe use, storage, and transportation. Particularly, it is critical that firearms be kept from unauthorized use, and this includes children. Your responsibility also includes, but is not limited to, the need to protect yourself and others from injury resulting from the misuse or abuse of a firearm.

»Treat firearms as though they are loaded.

»Always be aware of where the muzzle is pointed.

»Carry your firearm in a way that will preclude accidental injury to yourself or others in the event you should stumble, fall, or drop the firearm.

»Before shooting, make certain the barrel has no obstructions.

»Do not allow a firearm or ammunition to be left unattended. Secure both the firearm and ammunition from access by unauthorized people, including children.

»When shooting, always be certain that the area beyond the target, including the backstop, is clear and safe. Also make certain that shots fired present no safety hazards for yourself, or others.

»Always use both ear and eye protection when shooting.

»Always use factory loaded ammunition designed for and intended to be used in the firearm you are shooting. It must be the proper caliber (gauge)and type for your firearm.

»Always understand the proper operation of your firearm, and never allow the firearm to be used by anyone who does not understand how to use the firearm properly and safely.

»Never pass a firearm to another person unless the action is open and the firearm is in an unloaded and safe condition. Never put your finger into the trigger guard until you are ready to shoot.

»When not using the firearm, ensure that it is unloaded.

SAFETY WARNING: Discharging firearms in poorly ventilated areas, cleaning firearms or handling ammunition may result in exposure to lead and other substances known to cause birth defects, reproductive harm and other serious physical injury. Have adequate ventilation at all times. Wash hand thoroughly after exposure.

Store your firearm unloaded and in an area which is secure from unauthorized access. Furthermore, store ammunition separately, and in an area secure from unauthorized access.

WE SPECIFICALLY DISCLAIM ANY RESPONSIBILITY FOR DAMAGE OR INJURY WHATSOEVER OCCURRING IN CONNECTION WITH, OR AS A RESULT OF, THE USE OF FAULTY, NON-STANDARD, OR "REMANUFACTURED" OR HAND LOADED (RELOADED AMMUNITION). Use special ammunition only as directed. ADDITIONALLY, WE DISCLAIM ANY RESPONSIBILITY FOR DAMAGE OR INJURY WHICH RESULTS FROM ANY MODIFICATIONS OR CHANGES THAT ARE NOT A PART OF THE FIREARM AS DELIVERED FROM THE FACTORY.

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Distributed by:

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